

5/38

DART AEROSPACE LTD	Work Order:	24246
Description: Shim	Part Number:	D3442-5
Dwg: D3442 Rev. A	Qty:	100 104
Ref:		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	[Signature]	05.09.14	100
2	PG	Issue P/O: <u>2008626</u> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3442 Possible Supplier: Industrial Laser Material release note is required	[Signature]	05.09.14	100
3	RG	Receive and Inspect for transit damage Enure material release note is attached	[Signature]	05/11/04	104
4	QC6	Inspect dimensions as per Dwg D3442	[Signature]	05/11/23	104
5	ST	Identify and Stock in WS cell	[Signature]	05/11/23	104
6	AC	Cost / part: _____	[Signature]	05-11-24	104
7	DC	Close W/O Inspect Level 21	[Signature]	05/11/24	104

Rev	Date	Change	Revised By	Approved
A	05.09.02	New issue	KJ/JLM	[Signature]

RELEASED
05-09-07

PTO

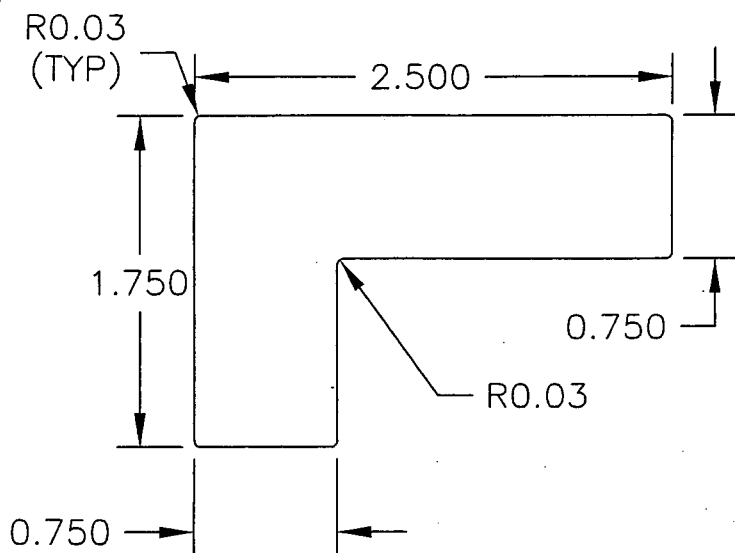
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 24246		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-10-19	2/	material not the right size. .034, need .063.		NO No good. - Notify supplier to read Dwg for mat'l thickness Supplier replaced N/C	W 05.11.23		W	2 05-10-19

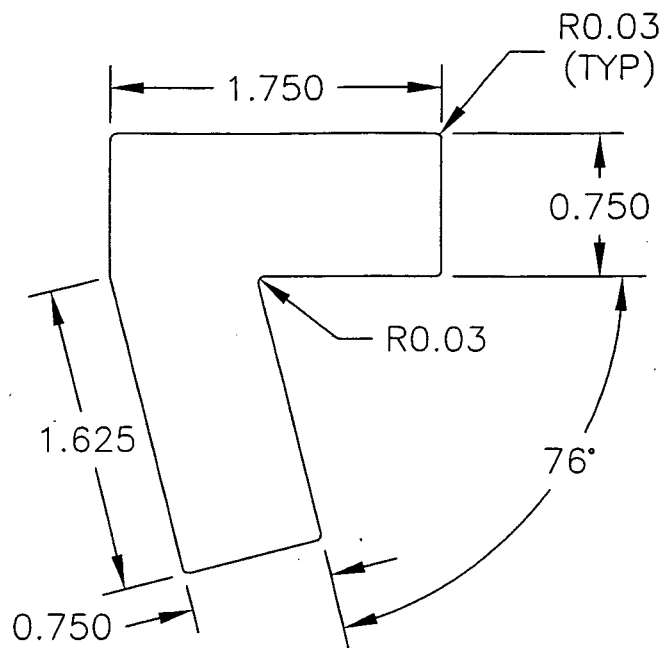
Part No: D3442-5 PAR #: 11/1A Fault Category: Supplier NCR: Yes No DQA: [Signature] Date: 05/11/24
 NOTE: Date & initial all entries Industrial Laser QA: N/C Closed: [Signature] Date: 05.11.24



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3442	REV. A SHEET 1 OF 1
DATE 05.06.03	TITLE SHIM		SCALE 1:1
A	05.06.03	NEW ISSUE	



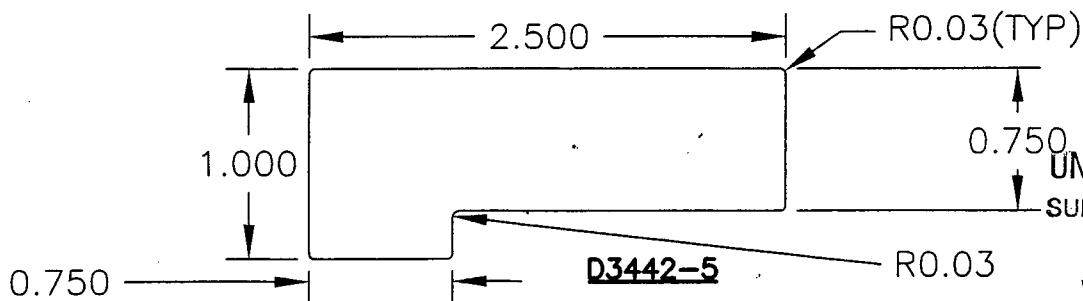
D3442-1



D3442-3

D3442-1/-3 SHIM

- 1) MATERIAL: AISI 304/316 SS SHEET 21 GAUGE (0.034 THICK)
(REF DART SPEC M304S21GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D3442-5

D3442-5 SHIM

- 1) MATERIAL: AISI 304/316 SS SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 24246

RELEASED

05.08.19 [Signature]

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 13, 2005
03:34 pm

Work Order No : 0024246
Project Name : D3442-5
Project For : WK538
Work Order Type : Main
Main WO Number :
House Part Number : D3442-5
.Description : Shim
Manufactured : Yes
Amount Req'd : 100
Amount Done : 0
Start Date : 09-12-05
Est Finish Date : 09-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

MATERIAL TEST/INSPECTION CERTIFICATE

7026 4250

工廠:高雄縣路竹鄉順安路345號
345, SHUN AN RD. LU CHU HSI
KAOHSIUNG TAIWAN R.O.C.
TEL:(07)6972885 FAX:(07)697300
CERTIFICATE NO: F05M438R
DATE OF ISSUE:05/31/2005
PAGE:12

SPECIFICATION:
CUSTOMER

AIISI 304
INTEGRIS METALS LTD

INTEGRIS METALS LTD																					CERTIFICATE NO: F05M438R			
BUYER'S ITEM NO.		SIZE	NO.	Weight (N.W.)		Heat No.	ID NO.	Physical Properties					Chemical Composition											
								Tensile Test					(%)											
				GL=50 m/m					Y.S.	T.S.	E.L.	HRB	H V	C	Si	Mn	P	S	Ni	Cr	N			
					(N/mm ²)	(N/mm ²)	(%)				x100	x100	x100	x1000	x1000	x100	x100	x100						
AIISI 304, NO.4 (SIC) FINISH, WITH 100 MIC. FILM ON MAIN SIDE, WITH BACK-PASS, SLITTED EDGE.																								
7425-6500	22GA/48"X120"	1	1,431	3,155	YU233277	43S60990B-213	283	662	54	84	169	4.3	48	121	29	6	820	1823	3.4					
7425-6500	22GA/48"X120"	1	1,432	3,157	YU233277	43S60990B-214	283	662	54	84	169	4.3	48	121	29	6	820	1823	3.4					
7425-8961	20GA/30"X120"	1	1,248	2,740	YU233391	43S61959B-121	275	669	51	81	158	4.5	52	106	29	4	810	1814	2.6					
7425-9040	20GA/36"X120"	1	1,334	2,941	YU136787	43S61422-2114	307	719	47	82	162	4.6	44	124	36	9	806	1838	2.4					
7425-9215	20GA/48"X120"	1	1,456	3,210	YU135718	44S65223-12	295	669	51	82	161	4	47	107	27	4	804	1822	2.5					
7425-9215	20GA/48"X120"	1	1,456	3,210	YU135718	44S65223-13	295	669	51	82	161	4	47	107	27	4	804	1822	2.5					
7425-9240	20GA/48"X144"	1	1,377	3,036	YU135406	44S65245-11	283	653	53	82	161	4.9	48	117	24	3	802	1822	2.6					
7425-9240	20GA/48"X144"	1	1,376	3,034	YU135406	44S65245-12	283	653	53	82	161	4.9	48	117	24	3	802	1822	2.6					
7425-9155	20GA/48"X 96"	1	1,441	3,177	YU135406	44S65245-13	283	653	53	82	161	4.9	48	117	24	3	802	1822	2.6					
7426-3390	18GA/36"X120"	1	1,440	3,175	YU233451	44S65725B-114	313	665	49	85	171	4.2	47	116	37	7	804	1831	2.6					
7426-3390	18GA/36"X120"	1	1,437	3,168	YU233451	44S65725B-115	313	665	49	85	171	4.2	47	116	37	7	804	1831	2.6					
7426-3530	18GA/48"X144"	1	1,412	3,113	YU233636	44S64477BB-11	293	667	50	81	159	4.6	52	118	30	4	807	1816	2.9					
7426-3539	18GA/60"X120"	1	1,430	3,153	YU136654	42S58014A-11	277	673	51	80	155	3.9	52	107	25	3	806	1824	2.3					
7426-6064	16GA/36"X120"	1	1,414	3,117	YU233334	43S62230-114	289	671	48	81	156	4.4	55	117	27	8	806	1813	3.2					
7426-6288	16GA/48"X120"	1	1,475	3,252	YU137028	44S65863-15	293	663	51	80	155	4.9	50	114	31	3	805	1817	2.9					
7426-6159	16GA/48"X 96"	1	1,478	3,247	YU137028	44S65863-16	293	663	51	80	155	4.9	50	114	31	3	805	1817	2.9					
7426-6159	16GA/48"X 96"	1	1,493	3,291	YU137028	44S65863-12	293	663	51	80	155	4.9	50	114	31	3	805	1817	2.9					
7426-6159	18GA/48"X 96"	1	1,492	3,289	YU137028	44S65863-13	293	663	51	80	155	4.9	50	114	31	3	805	1817	2.9					
7426-6353	16GA/60"X120"	1	1,492	3,289	YU137028	44S65863-14	293	663	51	80	155	4.9	50	114	31	3	805	1817	2.9					
7426-6353	16GA/60"X120"	1	1,407	3,102	YU137380	44S64702C-311	285	665	50	80	154	4.1	52	116	35	3	808	1818	2.6					
7426-9049	14GA/48"X120"	1	1,460	3,219	YU137380	44S64702C-312	285	665	50	80	154	4.1	52	116	35	3	808	1818	2.6					
7426-9049	14GA/48"X120"	1	1,476	3,254	YU230937	44S67868A-15	315	649	49	85	170	4	50	113	25	3	815	1833	3.5					
7426-9049	14GA/48"X120"	1	1,472	3,245	YU230937	44S67868A-16	315	649	49	85	170	4	50	113	25	3	815	1833	3.5					
7426-9033	14GA/48"X 96"	1	1,472	3,245	YU230937	44S67868A-17	315	649	49	85	170	4	50	113	25	3	815	1833	3.5					
7427-4844	12GA/48"X120"	1	1,428	3,148	YU230936	44S67866B-16	295	657	50	81	157	3.8	50	111	26	2	812	1808	3					
7427-7177	11GA/48"X120"	1	1,448	3,192	YU136911	44S64898-111	294	637	54	82	161	4.4	51	127	30	3	818	1807	2.7					
7427-7177	11GA/48"X120"	1	1,398	3,082	YU233718	44S64926A-2118	305	626	53	82	162	4	50	138	29	8	811	1822	3.3					
7427-7177	11GA/48"X120"	1	1,389	3,062	YU137453	44S65351A-111	318	669	51	84	167	4.5	47	115	31	2	808	1832	3.5					
Remarks:			28	40,054	88,303																			
NO MERCURY CONTAMINATION																								
Bend test:good for all Heat NO																								
E HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS																								
EN MADE IN ACCORDANCE WITH																								

marks: 28 40,054 88,303
NO MERCURY CONTAMINATION
I HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS
EN MADE IN ACCORDANCE WITH THE RULES OF THE MILL CERTIFICATE.

Bend test: good for all Heat NO.

- PRIME MATERIAL. NO DINGS, NO DENTS, NO SCRATCHES
- P.O. NO. 447002 (VANCOUVER)
- SALES CONTRACT: F05M438
- DOCUMENTARY CREDIT NUMBER: ILCMSP002723

YIEH MAU CORP.

Manager of Quality Assurance Section

10/19/2005 08:42 FAX 6042729137 INTEGRIS METALS 006/007

Date: Saturday, 11/19/2005 8:40:08 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SHIM
Job Number :	24246		
Estimate Number :	10772		
P.O. Number :		Part Number :	D34425
This Issue :	11/19/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3442 REV A
First Issue :	/ /	Project Number :	
Previous Run :		Drawing Revision :	A
	Type :	Material :	
	PURCHASED PARTS	Due Date :	11/26/2005
Written By :		Qty:	104
Checked & Approved By :		Um:	Each
Comment :	Est. A 05.09.02 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: _____

Email or Ship DXF file to vendor

Laser Cut flat pattern per Dwg D3442

Possible Supplier: Industrial Laser

Material release note is required

2.0	D34425F	Shim
-----	---------	------

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Saturday, 11/19/2005 8:40:08 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHIM

Job Number: 24246

Part Number: D34425

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
11:12 am

Work Order No : 0024246
Project Name : D3442-5
Project For : WK538
Work Order Type : Main
Main WO Number :
House Part Number : D3442-5
Description : Shim
Manufactured : Yes
Amount Req'd : 104
Amount Done : 0
Start Date : 09-12-05
Est Finish Date : 09-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	80.00	100.00	0.00	80.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	80.00	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	80.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-80.00)